

Date: Tuesday, 29/04/2008 10:45:25 AM
 User: Linda Lacelle

Process Sheet

OK

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: FRONT INBOARD LEG		
Job Number	: 38876		Part Number	: D37681		
Estimate Number	: 10804		Drawing Number	: PROTOTYPE		
P.O. Number	:		Project Number	:		
This Issue	: 29/04/2008 S.O. No. :		Drawing Revision	: 08.04.23		
Prsht Rev.	: NC		Material	:		
First Issue	: 29/04/2008 Type : R & D SM/MED FAB		Due Date	: 16/05/2008 Qty: 2 Um: Each		
Previous Run	: 38866					
Written By	:					
Checked & Approved By	:					
Comment	:					

Additional Product

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	SMALL FAB 1	SMALL & MEDIUM RESOURCE 1	X2
Comment: SMALL & MEDIUM FAB RESOURCE 1			
MAKE PER DRWG D3768 REV A			
2.0	M6061T6T1000W065	6061T6 TUBE	10.25" M18188 X1 M18639 X1 ml08/05/07
Comment: Qty.: 0.9000 f(s)/Unit Total : 1.8000 f(s) 6061T6 TUBE			
3.0	QC5	INSPECT WORK TO CURRENT STEP	ml08/05/07
Comment: INSPECT WORK TO CURRENT STEP			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	08/05/08 (2)
Comment: HAND FINISHING RESOURCE #1			
ACID ETCH AND ALODINE PER QSI 005			

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION	08/05/08 (2)
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION			

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Drawing Name: FRONT INBOARD LEG

Job Number: 38876

Part Number: D37681

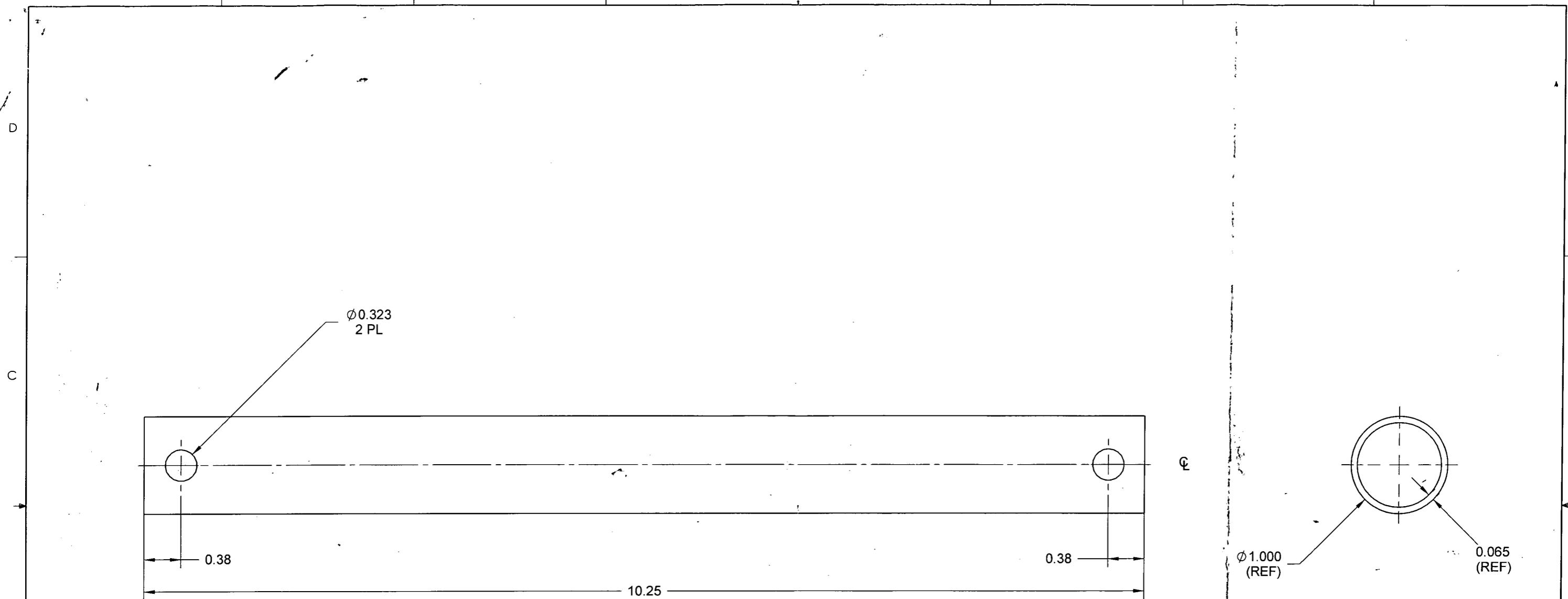
Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		FOR ENGINEERING USE ONLY
GIVE TO CHRIS P-ENG		<i>PSL 08.05.29</i>
CHARGE TO JOB #00196		
7.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		<i>KA 08.05.29</i>
Job Completion		<i>Prototype</i>

U 08.06.11

8 7 6 5 4 3 2 1



D3768-1 FRONT INBOARD LEG

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
08.04.23

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		D3768	
APPROVED		REV. A	
DE APPR.		SHEET 2 OF 4	
DATE	08.03.26	TITLE	SCALE
		FRONT LEG	1:1

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8 7 6 5 4 3 2 1

D

D

C

C

B

B



D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH



D3768-4 FRONT OUTBOARD LEG, RH **PHOTO TYPE**

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

08.04.23

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" OD X 0.065" WALL (REF. DART SPEC. M6061T6T1.00W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

REV.	DESCRIPTION		BY	DATE	
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	HS				
CHECKED			DRAWING NO.		
MFG. APPR.			D3768	REV. A	
APPROVED				SHEET 1 OF 4	
DE APPR.			TITLE	SCALE	
			FRONT LEG	NTS	
DATE	08.03.26		COPRIGHT © 2008 BY DART AEROSPACE LTD		
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Receiving Report

Date: 05/09/27
 Supplier: Acier Campi

Batch No: 18G39
 Dart P/O: 2008702

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr.

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No
 Shipment Complete: Yes No
 Q.C. Inspection _____

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
<u>M6061T6S.125</u>		<u>96</u>	<u>0</u>		<u>96</u>	

TSR No. _____

Initials of receiver (if shipment OK) DL

Accounting:

Date _____
 AP/MR _____
 Initial _____

Production/Admin:

Date 05/09/27

Received/Costing 2008702

Initial SL

H:\ISO9000\Forms\Purchase\RECREPORT rev B

MATERIAL: 6061-T6 OR 6061-T62 TUBING PER
 WW-T-700/6 OR AMS4080 OR AMS4082 OR
 QQ-A-200/8 OR QQ-A-225/8

6061T6 TUBE 1.500X .125W

09-27-5

2.6000 /f

156.00

Total Value of Purchase Order

\$1,083.60

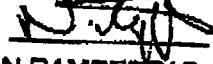
Ab 5/23

SAMPLE (S) OF ALUMINUM

REPORT: 38548

DIE NO.	H-2367
DESCRIPTION	1" O.D.X0.060" TUBE
AL. ALLOY & TEMPER	6061/T6
EXTRUDEX ORDER NO.	73632-5-A.11
SPECIFICATION	ASTM B221 (P note ACCEPTABLE, THIS INSTANCE ONLY PB 08.05.29)
SILICON %	0.54
IRON %	0.17
COPPER %	0.18
MANGANESE %	<0.01
MAGNESIUM %	0.80
CHROMIUM %	0.07
ZINC %	<0.01
TITANIUM %	<0.01
ALUMINUM %	REMAINDER
ALLOY TYPE %	6061
ALLOY CAST NO.	05072822A
YIELD STRENGTH (IN ksi)	37.1
TENSILE STRENGTH (IN ksi)	42.4
ELONGATION % IN 2"	11.0
HARDNESS (ROCKWELL 'F')	87.9 87.1 87.6

DATE:


 N. RAMPERTAB
 (LAB TECH)
 JULY-18-05

Receiving Report

Date: 05/08/02
 Supplier: Marinette Key Stone

Batch No: M18168
 Dart P/O: 2008300

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr.

Release Note Attached: Yes No
 Waybill Attached: Yes No
 Shipment Complete: Yes No
 Q.C. Inspection: U

Discrepancies

Part No.	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M60617671.750 W.065		300	228		72	

TSR No. _____

Initials of receiver (if shipment OK) DW

Production/Admin: 05-08-02
 Date 05-08-02
 Received/Costing 7-8300
 Initial LA
 H:\ISO9000\Forms\Purchase\RECREPORT rev B

Accounting:
 Date _____
 AP/MR _____
 Initial _____

216/FT	** 05/08/02, 1461978	ATS 1.750 .065	D6061	HT#.....: 1461978	Total... 18	216/FT
228 DW 05/08/02					18	216/FT

No. of Bdls/Pieces

4/ 1

Total Weight.....:

202

Customers.: _____

From: MARMON/KEYSTONE

To:

OR. REF:

SLSPRS:

1278GD

INIT.:

KAISER CHANDLER**CERTIFICATION and
PHYSICAL TEST RESULTS**

QP 026A

CHANDLER PLANT
BOX 5011 8573 W WILLIS ROAD
CHANDLER AZ 85226
PH: 520.798.1097
FAX: 520.798.0596
SALES: 800.528.8274

These results are for

MARMON/KEYSTONE CORP**175-42921.**Purchase Order No **60-17566-005**

Mill Number

Alloy **6061 Temper..... T6**

Part No, Item No, Commodity No or Inventory No

Size Description.

1.00 IN OD X .065 IN WALL

Specification(s).

WW-T-700/6F ASTM B210-04 AMS 4082N

Additional procedures as called for on Specification:

MADE IN U.S.A. WE TAKE EXCEPTION TO PARA. 5.2.1. Per AMS 4082N, WAS NOT OILED.

Chemical Composition Per Aluminum Standards and Data 2003											
Limits	MIN	0.40	*	0.15	—	0.8	0.04	—	—	Ea 0.05	Remainder
MAX	0.8	0.7	0.40	0.15	1.2	0.35	—	0.25	0.15	Total 0.15	
Actuals	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Tl	Others	Al
	0.64	0.25	0.21	0.03	0.93	0.07		0.02	0.02	Each 0.05	Remainder
	0.61	0.32	0.23	0.02	0.95	0.06		0.05	0.02	Total 0.15	

* For WW-T-700/4 specification, maximum Si plus Fe is .45%.

** 1100 Alloy Max Si + Fe is 0.95 %

Mechanical Properties	Lot #	Temp	Yield PSI	Ultimate PSI	Elongation %
	42921	D1T6	42,900	47,100	14

Q. C. REVIEWED

We hereby certify that the material covered by this report has been inspected in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description; and that samples representative of the material met the composition limits and had the mechanical properties as indicated.

Date 05/25/2005

*C E Brooks*C. E. BROOKS
Tech. Mgr. Tube

CertAct

FormContract

AT 11.065 734